

Date: Monday, 22/12/2008 3:06:04 PM  
 User: Melanie Fauteux

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	LEFT ARM WELDMENT
<b>Job Number</b> :	44249		
<b>Estimate Number</b> :	12106		
<b>P.O. Number</b> :		<b>Part Number</b> :	D33541
<b>This Issue</b> :	22/12/2008	<b>Drawing Number</b> :	D3354 REV.C
<b>Prsht Rev.</b> :	NC	<b>Project Number</b> :	N/A
<b>First Issue</b> :	//	<b>Drawing Revision</b> :	C
<b>Previous Run</b> :	36231	<b>Material</b> :	
<b>Written By</b> :		<b>Due Date</b> :	20/01/2009
<b>Checked &amp; Approved By</b> :	<u>310 0812.23</u>	<b>Qty:</b>	10
<b>Comment</b> :	est rev. A New issue EC Est Rev:B 07-12-10 rev C dwg DD verified by:EC		

Um: Each

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M4140HR1000	4140 round bar 1.00
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**Comment:** Qty.: 1.0763 f(s)/Unit Total: 10.7625 f(s)

AISI 4140 ROUND BAR

Dia. 1.00"

batch: 107676-4.5F7 110414-6-2625

09/01/10

10 pcs

2.0	BAND SAW	BAND SAW
-----	----------	----------



**Comment:** BAND SAW

Cut blank 12.30" long

09/01/10

10 pcs

3.0	LATHE CONV.	CONVENTIONAL LATHE
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**Comment:** CONVENTIONAL LATHE

Turn as per Dwg D3354

09/01/11

10 pcs

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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**Comment:** CONVENTIONAL MILLING MACHINE

1- Mill as per dwg D3354

2-Deburr as per dwg D3354

09/01/12

10 pcs

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	----------------------------------------



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

09/01/12

10 pcs

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 22/12/2008 3:06:04 PM  
User: Melanie Fauteux

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LEFT ARM WELDMENT

Job Number: 44249

Part Number: D33541

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

mk 09/01/03

(10)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

ST 491

AS 09/01/14 (10)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/15 AS

Job Completion



JW 09/01/14 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

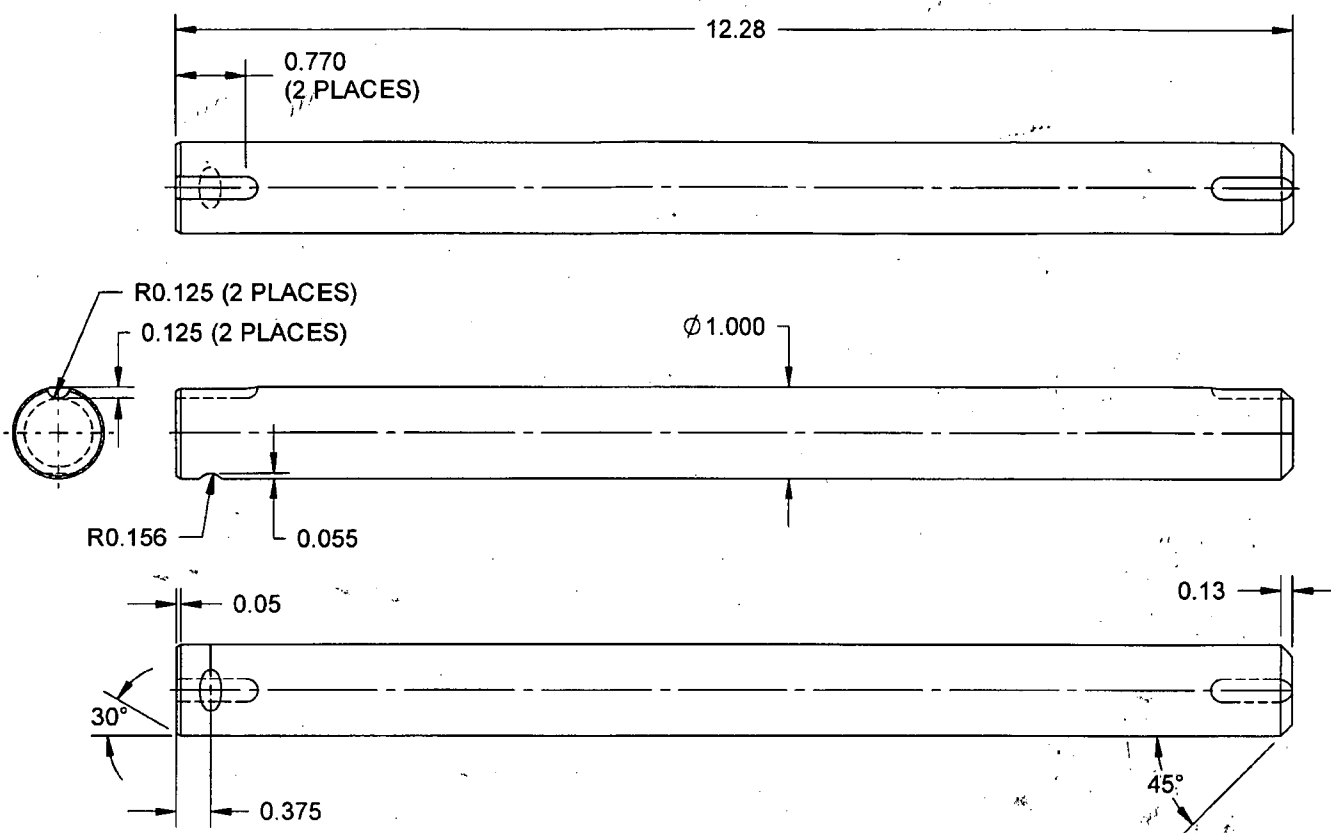
NOTE: Date & initial all entries





DESIGN <i>RF</i>	DRAWN BY <i>DC</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>g</i>	APPROVED <i>MP</i>	DRAWING NO. <b>D3354</b>	REV. C SHEET 3 OF 7
DATE <b>07.12.06</b>		TITLE <b>LEFT ARM WELDMENT</b>	SCALE 1:2

RELEASED  
*07/12/07 WP*



**D3354-1 INNER SHAFT**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *14249*

**NOTES:**

- 1) MATERIAL: AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-91 OR UNS#-G41400 ROUND BAR,  $\phi$  1.250 (REF. DART SPEC. M4140H-R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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